



# J O B H E A D E R

CUSTOMER..... DRAKE  
 PART NUMBER..... 21246  
 B/P NUMBER.....  
 PART NAME..... BUSHING PIN  
 PO NUMBER.....  
 LOG NUMBER..... 16-7962AN20  
 TOOL/MOLD NUMBER... 796-2  
 FIXTURE NUMBER.....  
 LAYOUT TYPE..... ANNUAL VALIDATION  
 JOB STATUS..... In Process  
 RESPONSIBILITY..... CMM  
 CHECK DATE..... 7/9/2020  
 INSPECTED BY..... R. SEYLER  
 GENERAL TOLERANCE 1 POS 2 POS 3 POS 4 POS 5 POS ANGLE  
 0.00000 0.00000 0.00000 0.00000 0.00000 0.00  
 PRECISION..... 3  
 UNIT OF MEASURE.... MM  
 JOB DATE..... 07/09/2020  
 REV. LEVEL & DATE... 10/26/2005 E  
 # PIECES..... 4  
 TOTAL FEATURES..... 16  
 MATERIAL..... DUPONT DELRIN BLACK  
 SIGMA..... 3.0  
 TOLERANCE PERCENT.. 80%  
 SHRINK FACTOR..... 0.0

COMMENTS: R. SEYLER

ANNUAL 2020



16-7962AN20/21246/BUSHING PIN/In Process/DRAKE/10/26/2005 E/07/09/2020

ROW DETAIL

BAL# / DESC FEATURE	NOMINAL TOLERANCE +/-	CAVITY 1 MEASURED OUT TOL	CAVITY 2 MEASURED OUT TOL	CAVITY 3 MEASURED OUT TOL	CAVITY 4 MEASURED OUT TOL
1	.25 +0.000/ -0.250 MV	0.230	0.210	0.250	0.220
2	.25 +0.000/ -0.250 MV	0.240	0.220	0.220	0.230
3	4.6 +/- 0.500 HG	5.060	5.100	5.080	5.070
4	11.76 +/- 0.250 C	11.950	11.970	11.950	11.980
5	.8 +/- 0.500 MV	0.740	0.780	0.760	0.770
5 A Degrees	45. +/- 5.000 MV	45.000	45.000	45.000	45.000
6 Min/Max	9.525/9.652 GP	9.630	9.620	9.650	9.630
7	.127 +0.000/ -0.127 CIRCULAR RUNOUT HG-GP	0.060	0.040	0.060	0.050
8 A	.8 +/- 0.500 MV-45 DEGREE CHAM	0.760	0.770	0.760	0.780
8 B	.8 +/- 0.500 MV-45 DEGREE CHAM	0.800	0.770	0.760	0.750
9 Diameter	15.75 +/- 0.250 C	15.720	15.720	15.710	15.700
10 Min/Max	18.695/18.923 C	18.810	18.790	18.810	18.820
11	.25 +0.000/ -0.250 MV	0.230	0.240	0.220	0.230
12 Min/Max	.051/0.508 MV-RADIUS	0.300	0.300	0.300	0.300



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ROW DETAIL - (Continued)

BAL# / DESC	NOMINAL	CAVITY 1	CAVITY 2	CAVITY 3	CAVITY 4
FEATURE	TOLERANCE +/-	MEASURED	MEASURED	MEASURED	MEASURED
		OUT TOL	OUT TOL	OUT TOL	OUT TOL
13	.25 +0.000/ -0.250 MV	0.220	0.230	0.210	0.220
14	0.0 +/- 0.000	CONFORMS	CONFORMS	CONFORMS	CONFORMS

MARK PER TES-002-5 WITH PART # SCRIBE ON PART REFLECT PART #

TOTAL # OF FEATURES	16				
LESS BASIC DIMENSIONS					
LESS EMPTY NOTES		0	0	0	0
LESS N/A DIMENSIONS		0	0	0	0
REPORTED DIMENSIONS		16	16	16	16
# DIMENSIONS IN TOLERANCE		16	16	16	16
# DIMENSIONS OUT OF TOLERANCE		0	0	0	0
% DIMENSIONS IN TOLERANCE		100.00%	100.00%	100.00%	100.00%
% DIMENSIONS OUT OF TOLERANCE		0.00%	0.00%	0.00%	0.00%
CUMULATIVE DIMENSIONS	64				
CUMULATIVE % (PIST) IN TOLERANCE	100.00%				



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OUT OF TOLERANCE SUMMARY

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BAL# / DESC	NOMINAL	CAVITY 1	CAVITY 2	CAVITY 3	CAVITY 4
FEATURE	TOLERANCE +/-	MEASURED	MEASURED	MEASURED	MEASURED
		OUT TOL	OUT TOL	OUT TOL	OUT TOL

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No Out Of Tolerance Features To Report For This Group.